

Date: Tuesday, 3/28/2006 3:02:23 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B FWD X-TUBE
Job Number	: 26379		
Estimate Number	: 12347		
P.O. Number	: <i>N/A</i>	Part Number	: D206667201
This Issue	: 3/28/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D206-667-241 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 26379	Drawing Revision	: B
Written By	: _____	Material	: <i>N/A</i>
Checked & Approved By	: _____	Due Date	: 4/30/2006
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D206-667-201 CHG002		
2.0	D6003102	Crosstube
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6003-102 Crosstube <u>1523967</u> Check OD = 2.250"; ID = 1.380"		
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084 2-Turn first side as per Folio FA084 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241. <i>BSG 06.03.31</i>		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET <i>BSG 06.03.31</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign. & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/28/2006 3:02:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Polish entire outside surface of crosstube

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

BC 06.03.31

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC 06.03.31

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/04/11

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JF 06/04/11

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

DP 06-10-10

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J 06-10-16 @

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

} 06-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment.

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

IT
06-10-13

INSPECT WORK TO CURRENT STEP

12.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

206-10-16 ①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

206-10-16/06

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

206-10-16

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 2246

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

206-10-16 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

206-10-16/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



206-10-19 (1)



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

FC 06 10 19 (1)

3-Paint outside crosstube with White Imron as per QSI 005 4.2

MM 06 10 19 (1)

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

206-10-20 (1)

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

628258 2T 06-10-20 (1)

21.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

628482

2T 06-10-20 (1)

22.0

MS2192020

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

15936 2T

06-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

} 25 06-10-20

24.0

QC5

INSPECT WORK TO CURRENT STEP



26-10-16 ①



Comment: INSPECT WORK TO CURRENT STEP

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

MS21042L5

Nut

✗



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101648

27.0

AN532A

Bolt

✗



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M102238

28.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

✓ 2 D2872-043

Nut Plate ~~2872043~~

B24151
25 06-10-19

29.0

D2872045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

✓ 2 D2872-045

Nut Plate ~~2872045~~

B24152
25 06-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt ~~M100440~~ M157291

31.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-30A

Bolt M19512

32.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

20 AN960JD516

Washer M101369

33.0

MS21042L5

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

6 MS21042L5

NUT M1-1648 -

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location:

PPP Rev:

B

P04/10/231

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 26379

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

①
D 06/10/23

Job Completion



U 06/10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 [Signature]

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

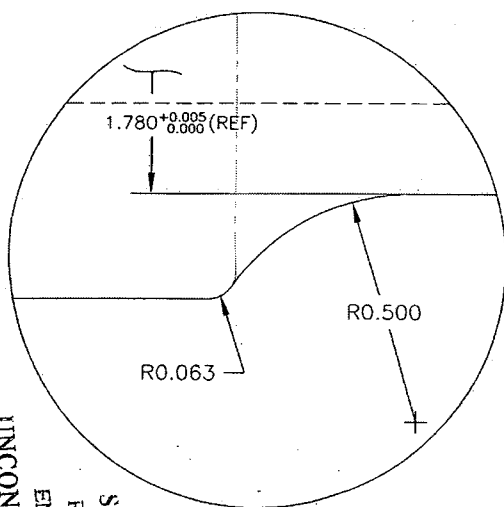
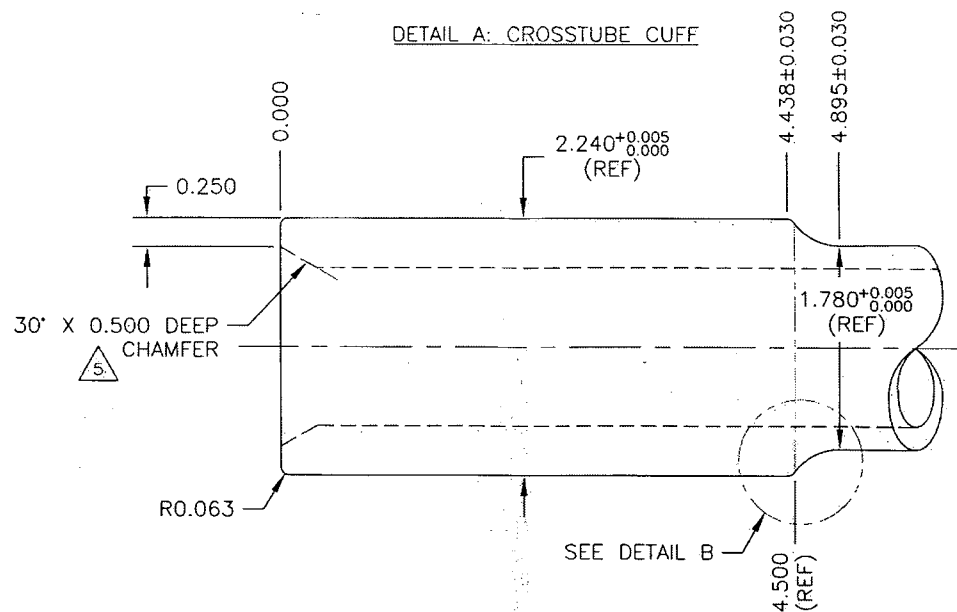
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26379

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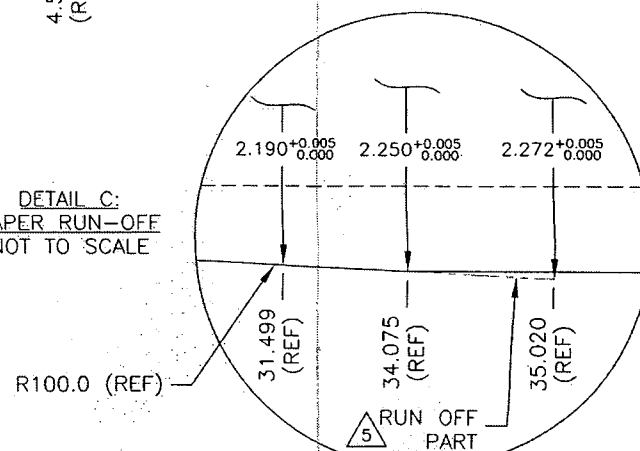
RELEASED
05-06-16-4

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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		DATE	05.02.04			D206-667-241	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206B HIGH AFT)	1:1

NO. 26379
WORK ORDER
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SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHO COPY

DAI/AEROSPACE LTD

Work Order:

Description: X-TUBE SIDE (B) A

Part Number: 206-667-201

Inspection Dwg: 206-667-241 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30° X.500	N/A	.375	✓			
.250	+ .01	.250	✓			
2.240	+ .005 - .006	2.244	✓			
4.438	+ .03	4.450	✓			
1.780	+ .005 - .000	1.785	✓			
.063	+ .01	.063				
1.851	+ .005 - .000	1.855	✓			
1.928	"	1.932	✓			
2.005	"	2.009	✓			
2.082	"	2.086	✓			
2.159	"	2.161	✓			
2.190	"	2.192	✓			
100.6	+ .02	100.6	✓			

Measured by:

BC

Date:

06-03-21

Audited by:

MB

Date:

06/04/01

Prototype Approval:

Date:

Rev: 1

Date:

Change

New Issue

Revised by
KJ/RF

Approved

DAVITA AEROSPACE LTD

Work Order:

Description:

X-TUNE SIDE S

Part Number:

206-667-201

Inspection Dwg: 206-667-241 Rev: 3

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30 x .500	N/A	.712				
.250	+ .01	.250				
2.240	+ .000 - .000	2.242				
4.438	+ .03	4.450				
1.780	+ .005 - .000	1.782				
.065	+ .01	.063				
1.851	+ .005 - .000	1.854	—			
1.928	"	1.930	—			
2.005	"	2.008	—			
2.082	"	2.085	—			
2.159	"	2.162	—			
2.190	"	2.192	—			

Measured by:

BC

Date:

06.03.31

Audit id by:

Date:

Prototype Approval:

Date:

Rev: A

Date:

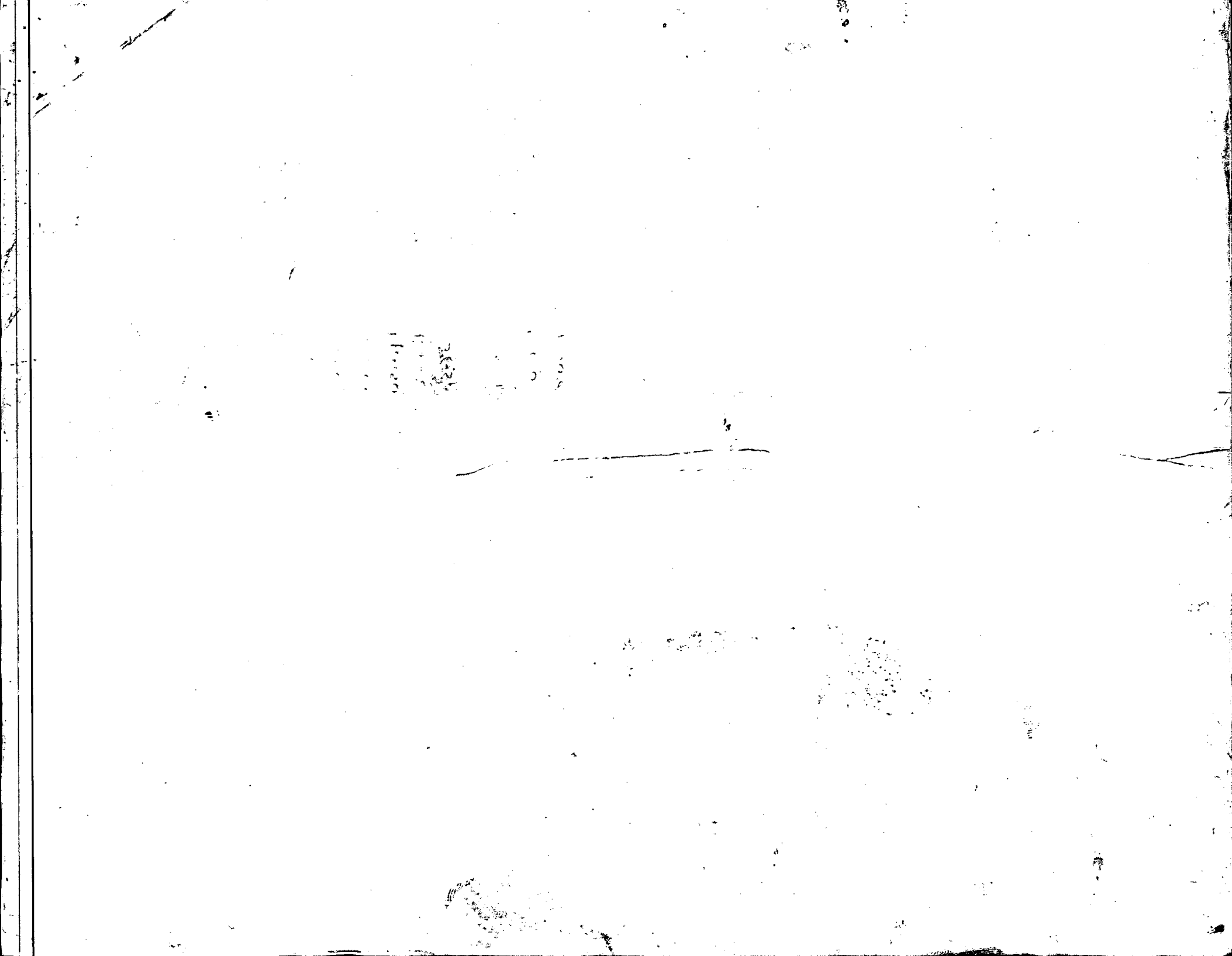
Change

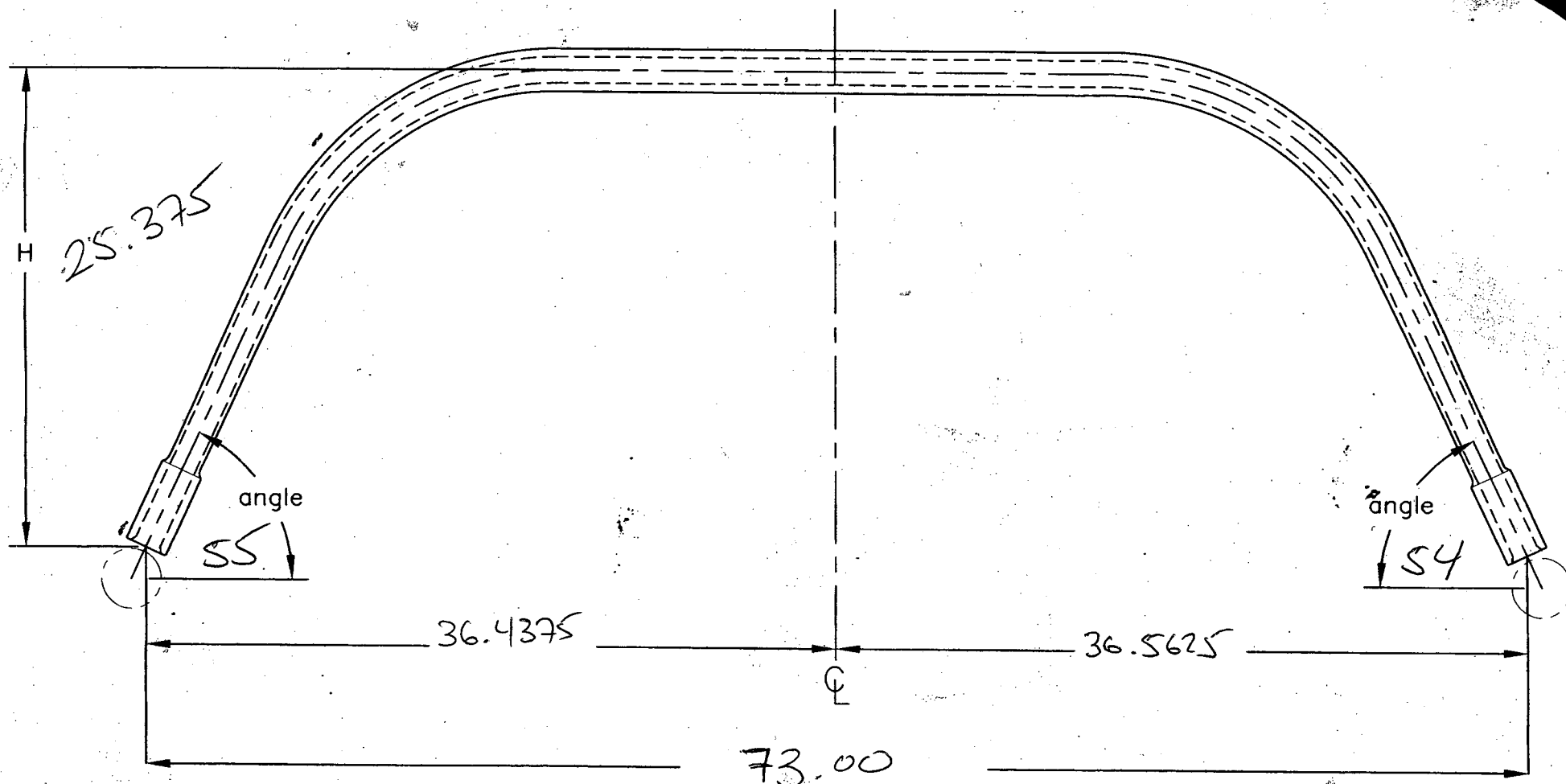
New Issue

Revised by:

Approved:

KJRF





DATE: 06.10.12

DESCRIPTION: 206-667-201

BATCH NO: B26379

DRAWING: 206-667-241 Rev.B

H: 25.04

1/2 SPAN: 36.60

TOTAL SPAN: 73.2

ANGLE: 65 ±2

.080 under Tolerance
1° under on one side.

Fits Table Jig pretty good,
only one Jig is slightly lifted not
even 3/16"

Bayer
Feb 10.12



**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lapine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35067

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D206-667-101 Cross tube S/N B28679.

Qty (3) P/N D058-676-201 Cross tubes S/N's B28678, B28677 and B19629.

Qty (1) P/N D206-667-201 Cross tube S/N B26379.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(5) cross tubes inspected. (5) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE October 17, 2006

INSPECTED BY: INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

2246

Linda

ADDRESS:

CONTACT NAME:

LABOUR

F. 613-632-1053

\$

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

ATTN: LINDA.

GST

PST

INVOICE NO.

TOTAL \$

